Dart Aerospace Ltd. Friday, 7/4/2008 12:48:28 PM Date: Kim Johnston User: **Process Sheet** : BUSHING : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 40277 **Estimate Number** : 10725 : D2652 **Part Number** P.O. Number D2652 REV A : 7/4/2008 S.O. No. : **Drawing Number** This Issue : N/A : NC Prsht Rev. Project Number First Issue : // Type : MACHINED PARTS **Drawing Revision** : 39222 Material Previous Run Each : 7/30/2008 Qty: 200 Um: **Due Date** Written By Checked & Approved By Comment : Est Rev:B 02.06.13 Now machined in house. NG **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: 1.0 M303R0500 303 Round Bar 0.500" Comment: Qty.: 0.0578 f(s)/Unit Total: 11.5500 f(s) Material:303 ss .500" Round Bar (M303R0500) Batch: <u>~\06996</u> 2.0 Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652 FOLIO REV: A 2-DEBURR AS REQUIRED INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1

Page 1

Identify and Stock

Location:

Dart Aerospace Ltd

W /O:		WORK ORDER C	HANGES	-			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #: Fault Category:	NCR: Yes	No DO	۱۸۰	Date:	
rait No	•	PAN # Fault Category		N/C Close			

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries

Date:

Friday, 7/4/2008 12:48:28 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40277

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



ms 08-07-15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category: f	NCR: Ye	s No DQ	A:	Date: _	
			QA:	N/C Close	d:	Date: _	

NCR:	:		WORK ORD	ER NON-CONFORMAN	CE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Arrification Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40277
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	2001	V			
0.060	+/-0.005	.060	V			
Ø0.305	-0.002/+0.000	×.304	J			
Ø0.191		Ø.193	V			
Ø0.500		Ø .500	8			
0.030 x 20°	+/-0.010	.030×20°	/			
R0.010	+0.010/-0.000	D10. A	V			
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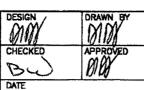
Measured by: MM	Audited by:	Prototype Approval:	N/A
Date: 08/07/11	Date: 08/07/15	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	. 4
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DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA DRAWING NO.

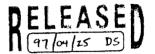
D2652

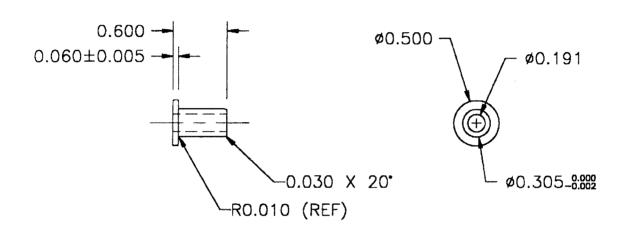
REV. A SHEET 1 OF 1

TITLE

SCALE

97:03:25 **BUSHING**





SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED